

Work Order ID 51298

August 15, 2009 10:35:00 AM



Page 1

Item ID: D3886-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Lug Assembly

Start Date: 08/17/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 08/21/2009 Req'd Qty: 9.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3886	B								
100		0.00							
Waterjet	Memo	0.00							
FLOW CNC Waterjet	FLOW WATER JET 1-Cut as per Dwg D3886 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

09 08 20 (12)

09 08 20 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51298

August 15, 2009 10:35:00 AM



Item ID: D3886-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Lug Assembly

Start Date: 08/17/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 08/21/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: MF Date: 09-08-15 Tooling: Date:

Run Start



QC: Date: SPC (Y/N): Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	=> 802/08/20			(412)	/		
130 Brake NC Brake NC	form as per dwg D3886 Memo	0.00 0.00	802/08/25			12	/		
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	-> 802/08/25			(412)	/		

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 51298

August 15, 2009 10:35:00 AM



Page 3

Item ID:	D3886-041	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Lug Assembly					
Start Date:	08/17/2009	Start Qty: 6.00		Cust Item ID:		
Required Date:	08/21/2009	Req'd Qty: 6.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

150		0.00							
Large Fab	Memo	0.00							
Large Fab	Weld as per Dwg D3886 and QSI 004 A/R SS ROD Batch: M1020000								

A 9-8-27 (12)

160	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									

D 09.08.27 (12)

170	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

=> 502/04/07

(12) p

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51298

August 15, 2009 10:35:00 AM



Page 4

Item ID:	D3886-041	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Lug Assembly					
Start Date:	08/17/2009	Start Qty: 6.00		Cust Item ID:		
Required Date:	08/21/2009	Req'd Qty: 6.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
	Powdercoat								
Powder Coating	Memo								
	START 10:30am Temp 400°F Finish 11:00	0.00							

190	QC3- Inspect Part Finish	0.00							
	QC								
Quality Control	Memo	0.00							

200	Identify as per dwg & Stock Location: 462	0.00							
	Packaging								
Packaging	Memo	0.00							

=>

BR 09-08-27-12.

9/8/28 @ SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 51298

August 15, 2009 10:35:00 AM



Page 5

Item ID: D3886-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Lug Assembly

Start Date: 08/17/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 08/21/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/08/31

PL 09-8-31 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

August 15, 2009 10:35:00 AM

Page 1

Work Order ID: 51298

Parent Item: D3886-041RevB

Parent Item Name: Lug Assembly


Comments:

Start Date: 08/17/2009

Required Date: 08/21/2009

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S12GA 		Purchased	No			100	sf	39.5900	11200	120		
304/316 0.100" Sheet												

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

MAT

39.59

105130

7.59

112290

32

D3886-1RevB

Manufactured No

150

Each

0.0000



Lug

~~112~~
10.0000


817
-10,65

105130

HB 9-8-17

EL

9-8-26

12

351299

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

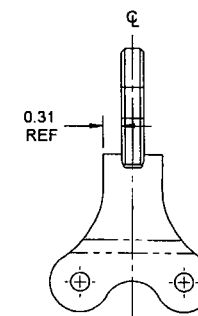
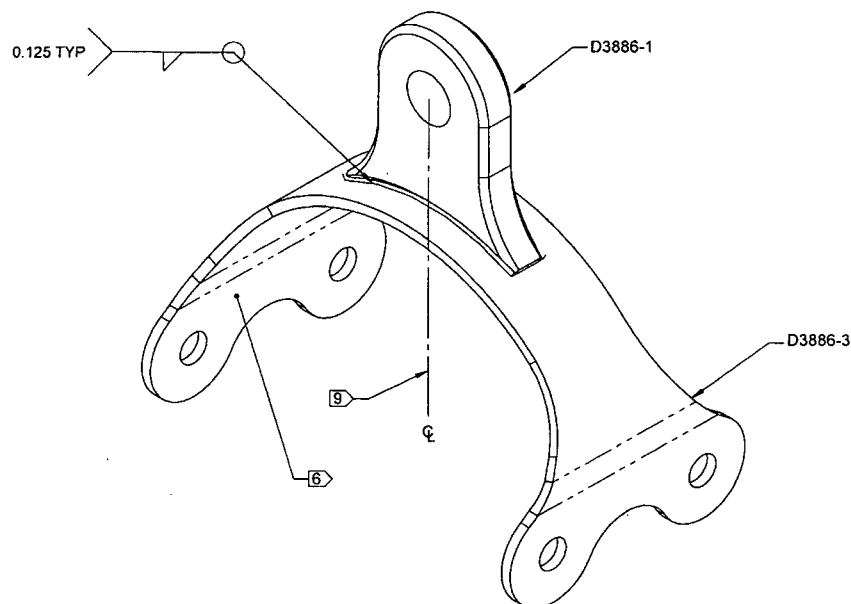
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3886-041	LUG ASSEMBLY
2	1	D3886-1	LUG
3	1	D3886-3	BRACKET



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. *mf 09-08-15*

D3886-041 LUG ASSEMBLY

RELEASED
8/6/09

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3886-041" AND BATCH NUMBER USING FINE POINT PERMANENT INK MARKER ON UNDERSIDE OF PART
- 7) WEIGHT: 0.53 lbs
- 8) WELD PER DART QSI 004
- 9) BOTH PARTS CENTER SHOULD BE IN LINE WITH THE ϕ

B	RE-DESIGN D3886-1 (ZN B4-2); RE-DESIGN D3886-3 (ZN A4-3); REVISED D3886-3F (ZN B4-4)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3886	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LUG ASSEMBLY	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

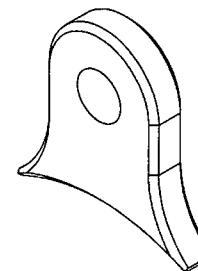
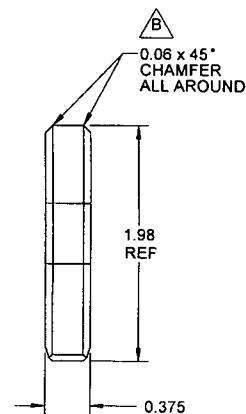
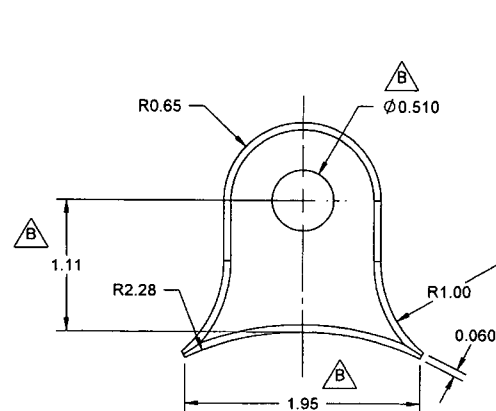
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3886-1 LUG B

51298

RELEASED
09/07/09

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR (REF. DART SPEC. M304B0.750X2.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.23 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3886	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LUG ASSEMBLY	NTS
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

D

C

B

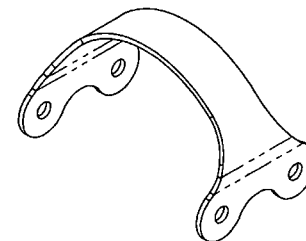
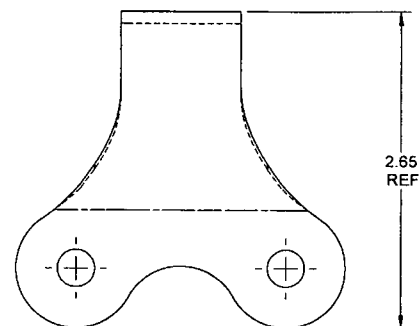
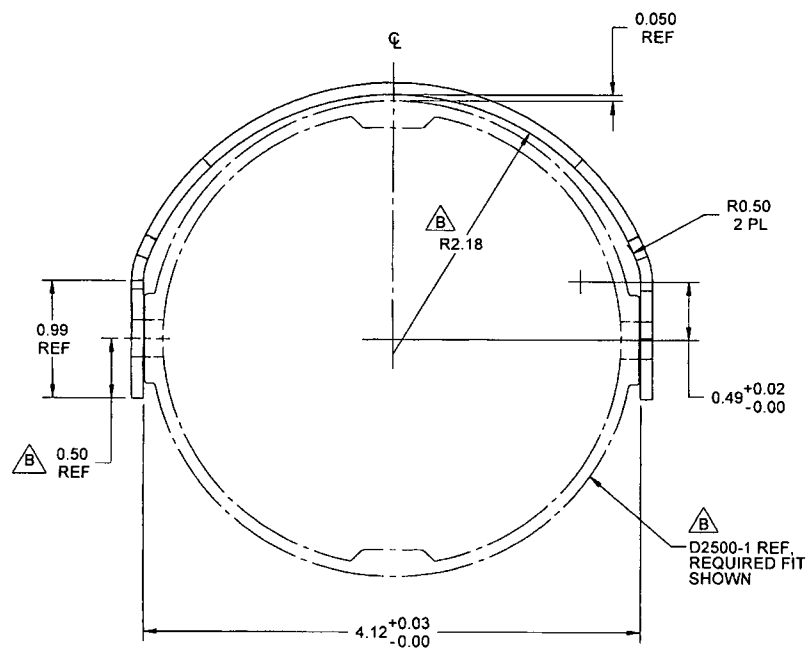
A

D

C

B

A



D3886-3 BRACKET B
(MAKE FROM D3886-3F)

51298

RELEASED
2017/15/17

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3886	REV. B
MFG. APPR.	<i>[Signature]</i>	TITLE LUG ASSEMBLY	SCALE NTS
DATE	09.06.30	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8

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4

3

2

1

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